

Date: Monday, 11/19/2007 4:04:17 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PEDAL ASSEMBLY		
Job Number	: 35853					
Estimate Number	: 10504					
P.O. Number	: N/A		Part Number	: D3204041		
This Issue	11/19/2007	S.O. No.	N/A	Drawing Number	: D3204 REV. A1	
Prsht Rev.	NC			Project Number	: N/A	
First Issue	N/A	Type	LARGE FAB ASSY	Drawing Revision	: A1	
Previous Run	34237			Material	: N/A	
Written By			Due Date	12/5/2007	Qty:	4
Checked & Approved By			Um:	Each		
Comment	: Est:C 05.08.11 Added Step 25 KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	D32041	Tube			
					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Tube Pick: Qty Part Number Description Batch 1 D3204-1 Tube B23928 → 4 ✓ 07/11/23					
2.0	D32043	Arm			
					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Arm Pick: Qty Part Number Description Batch 1 D3204-3 Arm B32840 → 3 ✓ 07/11/23					
3.0	D32045	Arm			
					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Arm Pick: Qty Part Number Description Batch 1 D3204-5 Arm B30896 → 1 ✓ 07/11/23					
4.0	D32049	Pedal			
					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pedal Pick: Qty Part Number Description Batch 1 D3204-9 Pedal B30897 → 1 ✓ 07/11/23					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 35853

Part Number: D3204041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D320411 Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Plate

Pick:

Qty	Part Number	Description	Batch
1	D3204-11	Plate	B32839



SL 07/12/19

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- Weld assembly as per Dwg D3204 using Jig D3204-041T1. ✓
- 2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld. ✓
- 3- Use JB weld compound to plug the hole after assembly. ✓
- 4- Grind JB weld flush after it is cured. ✓

Identify as D3204-041 ✓

SL 07/12/19

4X

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-12-19 (4)

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SL 07/12/20 (4)

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 07/12/27 (4)

10.0 POWDER COATING POWDER COATING



m105642

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Cover holes for bushing

SL 07/12/27 (4)

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

* D3204-13 Gusset Qty 2 batch: B35970
- 8 morceau

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 05/01/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 35853

Part Number: D3204041

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 D32047 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
2	D32047	Bushing	84722

7/12/27 50 4x

13.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install D3204-7 bushing as shown in Dwg D3204

SAD 07-12-27

③ X

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/12/26

③

15.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: OK

SB 07/12/26

③

16.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

HD 08/01/03

③

Job Completion



2008/1/3

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

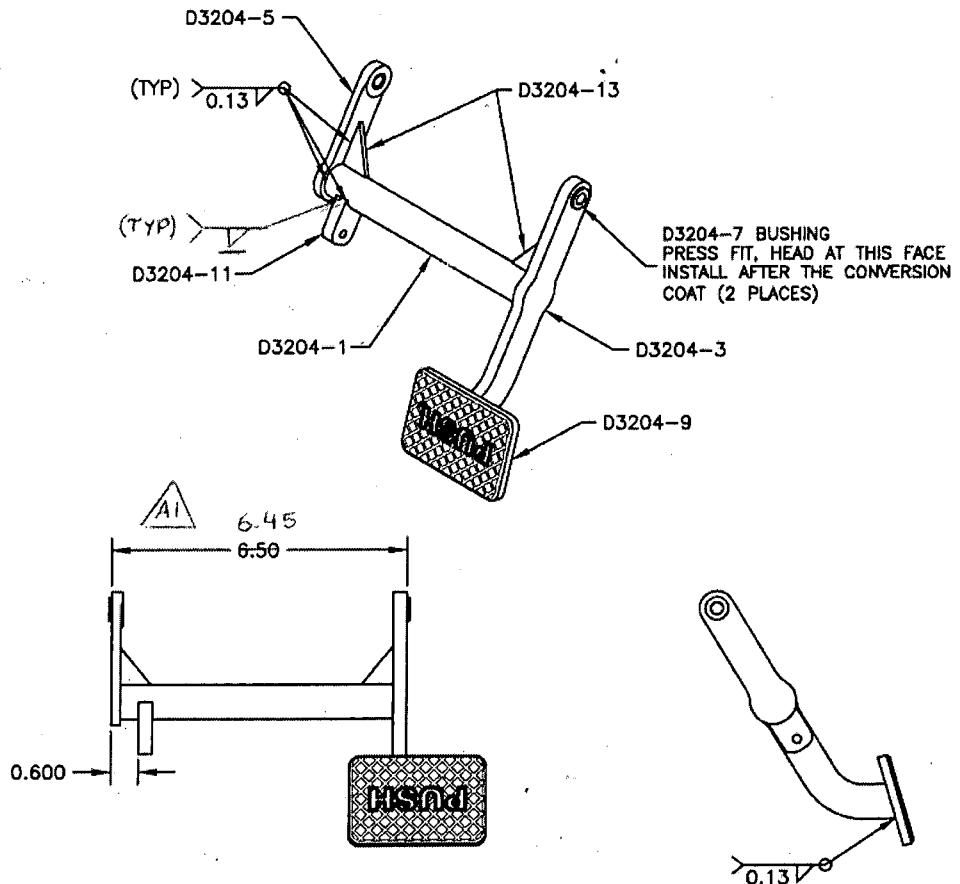
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/26	13.0	Q4Y7X The D3204-3 is severe, the hole for the bushing was oval, and left a gap at the top/bottom of the bushing, and tore the material on the edges.	Initial Chief Eng	Serviced, destroyed, Q4Y1 re-stocked D3204-7 bushings for this ass'y.	SAD 07-12-26	SD 07/12/26	07/12/26	07/12/27
		2-C: Operator error: machining						

NOTE: Date & initial all entries

DARTCOPY ISSUED
TO

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3204 REV. A
DATE		SHEET 1 OF 3
04.01.27		TITLE RELEASE PEDAL ASSEMBLY SCALE NTS
A	04.01.27	NEW ISSUE
A1	05.07.15	6.45 WAS 6.50

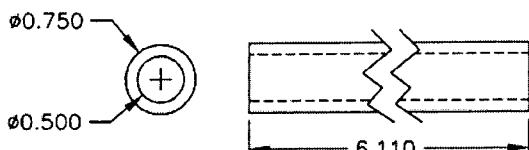
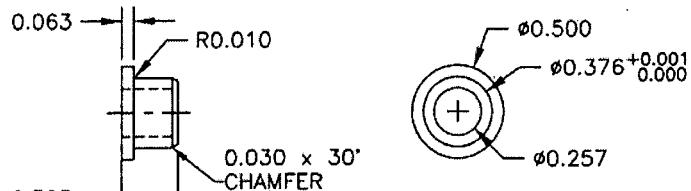
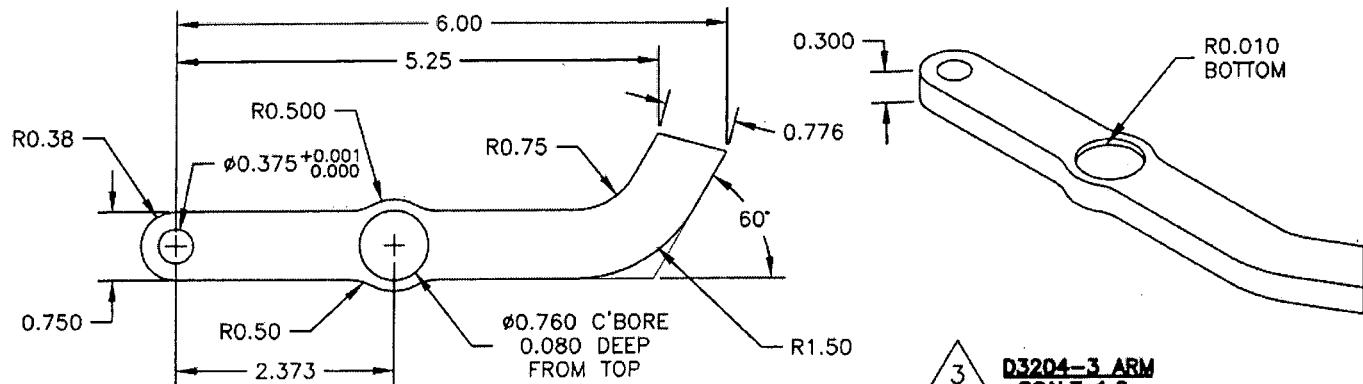
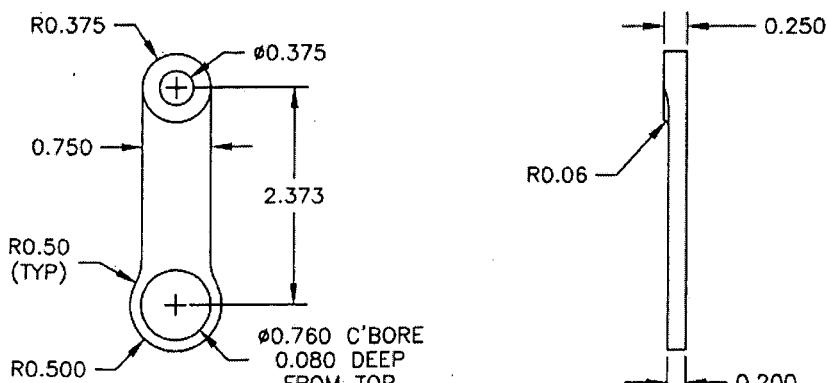
RELEASED
04.04.30**D3204-041 RELEASE PEDAL ASSEMBLY****NOTES**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

RELEASED
04.04.052 D3204-1 TUBE
SCALE 1:24 D3204-7 BUSHING
SCALE 1:13 D3204-3 ARM
SCALE 1:23 D3204-5 ARM
SCALE 1:2

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